Work Order ID 87491

87491

July-19-12 10:27:56 AM

Item ID: D130-701-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Heli-Utility-Basket

Start Date: 7/10/12 **Start Qty:** 1.00 *1*

Required Date: 9/07/12 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 12/07/20 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
IIN D130-701	C

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100		0.00							
100	DOCUMENT CONTROL					1			
DC	**Memo**	0.00							
Document Control	Photocopy blue file and type labels per PPP D130-701-041 CHG003								
110	Pick Kit	0.00							
110									
Packaging	**Memo**	0.00							
Packaging									
120		0.00							
120	Small Fab					1			
Small Fab	**Memo**	0.00							
Small Fab	Assemble as per Dwg IIN-D130-701								

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Item ID: D130-701-041 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Heli-Utility-Basket

Start Date: 7/10/12 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 9/07/12 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00				1			
130									
QC	**Memo**	0.00 12 05							
Quality Control									
140	Pick Kit	0.00				1X			12-6-4
140									
Packaging	**Memo**	0.00							
Packaging									
150	QC4- 100% Inspect kits for completeness	0.00				1			
150									
QC	**Memo**	0.00 13-1 22							
Quality Control									

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

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- ☐ Grain
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- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Item ID: D130-701-041 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Heli-Utility-Basket

Start Date: 7/10/12 **Start Qty:** 1.00 *1*
Required Date: 9/07/12 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Packaging		DAS 06 9-89			1	13/1/22		
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPP D130-701-041 Location: 102 PPP Rev: _____								
170	QC21- Final Inspection - Work Order Release	0.00							
170							13/1/23		
QC	**Memo**	0.00							
Quality Control									

MF
13-1-23

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

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- ☐ Turning Sequence
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- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
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- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
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- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

July-19-12 10:27:54 AM

Work Order ID: 87491
Parent Item: D130-701-041
Parent Item Name: Heli-Utility-Basket
Start Date: 7/10/12 **Required Date:** 9/07/12
Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:A02.12.04New issueKJ/RF
IPP Rev:B 07-06-28 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2512 Basket Lid 205/350		Manufactured	No			110	Each	0.0000	1	1	1		
D3172-041 Basket Base Assembly		Manufactured	No			110	Each	0.0000	1	1	1		
D2022-101 Spacer		Manufactured	No			110	Each	122.0000	2	2	2		

Location	Loc Qty	Loc Code
ST504	122	
73307	1	
79465	21	
83995	100	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2022-101 Spacer		Manufactured	No			110	Each	122.0000	2	2	2		

Location	Loc Qty	Loc Code
ST504	122	
73307	1	
79465	21	
83995	100	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2258-220 Placard		Manufactured	No			110	Each	15.0000	1				

Location	Loc Qty	Loc Code
ST505	15	
41266	5	
84458	10	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2332-041 Lid Prop Assembly 6.69" long		Manufactured	No			110	Each	7.0000	1	1	1		

Location	Loc Qty	Loc Code
ST512	7	
83994	7	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Inspection Strip in Tube
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General

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- ☐ Outside Dimensions
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- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID: 87491
Parent Item: D130-701-041
Parent Item Name: Heli-Utility-Basket
Start Date: 7/10/12 **Required Date:** 9/07/12
Start Qty: 1.00 **Required Qty:** 1.00

D2530 Handle Weldment	Manufactured	No		110	Each	2.0000	1	1 392799 SP

Location	Loc Qty	Loc Code
ST506	2	
82895	1	
83423	1	

D2535 Spring	Manufactured	No		110	Each	145.0000	2	2 SP

Location	Loc Qty	Loc Code
ST504	145	
83545	40	
86333	105	2x

D2537 Bushing	Manufactured	No		110	Each	8.0000	2	2 B85504 SP

Location	Loc Qty	Loc Code
ST504	8	
82896	8	

D2931 Bumper	Manufactured	No		110	Each	2,384.0000	2	2 SP

Location	Loc Qty	Loc Code
ST504	2384	
~~46064~~	384	2x
86435	2000	

AN3-16A Bolt	Purchased	No		110	Each	193.0000	2	2 SP 12-12-4

Location	Loc Qty	Loc Code
ST352	193	
117441	47	
118628	1	
121708	45	
122407	100	2x

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID: 87491
Parent Item: D130-701-041
Parent Item Name: Heli-Utility-Basket
Start Date: 7/10/12 **Required Date:** 9/07/12
Start Qty: 1.00 **Required Qty:** 1.00

AN4-7A Bolt	Purchased	No		110	Each	198.0000	2	2	SP.

Location	Loc Qty	Loc Code	
ST356	198		
120770	82		
122141	116		2X

AN4-22A Bolt	Purchased	No		110	Each	355.0000	1	1	SP

Location	Loc Qty	Loc Code	
ST358	200		
122416	200		1X
ST359	155		
116419	49		
118628	56		
120930	50		

AN4-24A Bolt	Purchased	No		110	Each	50.0000	1	1	SP

Location	Loc Qty	Loc Code	
ST359	50		
117514	50		1X

AN5-17A Bolt	Purchased	No		110	Each	172.0000	4	4	M/228008 12-12-4.

Location	Loc Qty	Loc Code	
338	4		
121181	4		
ST337	50		
122416	50		
ST338	118		
117872	34		
122151	84		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Work Order: _____

Part No. _____

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DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Crosstube ☐
- Water Jet ☐
- Engineering ☐
- Machining ☐
- Small Fab ☐
- Prod. Eng. Coor. ☐
- Quality ☐
- Thermoforming ☐
- Finishing ☐
- Rec/Store/Packaging ☐
- Other ☐
- Large Fab ☐
- Composite ☐
- Supplier ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID: 87491

Parent Item: D130-701-041 **Start Date:** 7/10/12 **Required Date:** 9/07/12

Parent Item Name: Heli-Utility-Basket **Start Qty:** 1.00 **Required Qty:** 1.00

AN960JD416 Washer	NAS1149D0463J	Purchased	No		110	Each	29.0000	2	2	M123355SP

Location	Loc Qty	Loc Code
ST351	29	
116289	8	
119097	21	

AN960JD416L Washer	NAS1149D0416J	Purchased	No		110	Each	6.0000	2	2	M123744SP.

Location	Loc Qty	Loc Code
FP002	6	
110153	6	

AN960JD516 Washer	NAS1149D0563J	Purchased	No		110	Each	12.0000	4	4	M123355SP

Location	Loc Qty	Loc Code
ST338	12	
2612	12	

AN960JD8 Washer	NAS1149DN832J	Purchased	No		110	Each	0.0000	2	2	M123348SP
AN970-4 Washer		Purchased	No		110	Each	193.0000	4	4	M122814SP 12124.

Location	Loc Qty	Loc Code
ST344	193	
104885	4	
105442	1	
107242	2	
10771	1	
115936	10	
120644	30	
121285	145	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID: 87491
Parent Item: D130-701-041
Parent Item Name: Heli-Utility-Basket
Start Date: 7/10/12 **Required Date:** 9/07/12
Start Qty: 1.00 **Required Qty:** 1.00

MS21042L3 Nut	Purchased	No		110	Each	3,103.0000	2	2 m12365SP

Location		Loc Qty	Loc Code	
ST300		1103		
	117885	32		
	119017	757		
	119075	138		
	121444	176		
ST317		2000		
	122141	2000		

MS21042L4 Nut	Purchased	No		110	Each	1,590.0000	4	4 m12302SP

Location		Loc Qty	Loc Code	
ST300		1590		
	104248	1		
	119075	116		
	121011	193		
	121444	1280		

MS21042L5 Nut	Purchased	No		110	Each	1,038.0000	4	4 m12245-2 SP 12-B-4

Location		Loc Qty	Loc Code	
300		500		
	121652	500		
ST300		538		
	108827	4		
	116105	5		
	116548	43		
	119109	474		
	17651	4		
	2937	8		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID: 87491
Parent Item: D130-701-041
Parent Item Name: Heli-Utility-Basket
Start Date: 7/10/12 **Required Date:** 9/07/12
Start Qty: 1.00 **Required Qty:** 1.00

MS20600-AD4W3 Cherry Rivets	Purchased	No		110	Each	1,142.0000	2	2

Location	Loc Qty	Loc Code
ST314	516	
122151	516	
ST321	493	
111636	36	
117601	3	
118626	222	
120308	232	
WA018	133	
107939	133	

D3173-041 Beam Assembly	Manufactured	No		140	Each	3.0000	2	2

Location	Loc Qty	Loc Code
ST167	3	
71275	3	

D3177-041 Bracket	Manufactured	No		140	Each	1.0000	1	1

Location	Loc Qty	Loc Code
ST201	1	
52894	1	

D3177-043 Bracket	Manufactured	No		140	Each	1.0000	1	1

Location	Loc Qty	Loc Code
ST201	1	
52895	1	

D3180-041 Strut Assembly	Manufactured	No		140	Each	5.0000	1	1

Location	Loc Qty	Loc Code
ST271	5	
70917	1	
71119	4	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Crosstube ☐
- Water Jet ☐
- Engineering ☐
- Machining ☐
- Small Fab ☐
- Prod. Eng. Coor. ☐
- Quality ☐
- Thermoforming ☐
- Finishing ☐
- Rec/Store/Packaging ☐
- Other ☐
- Large Fab ☐
- Composite ☐
- Supplier ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID: 87491

Parent Item: D130-701-041

Parent Item Name: Heli-Utility-Basket

Start Date: 7/10/12 **Required Date:** 9/07/12

Start Qty: 1.00 **Required Qty:** 1.00

D3181-1 Bushing	Manufactured	No		140	Each	29.0000	1

Location	Loc Qty	Loc Code
ST032	29	
18770	29	

AN4-7A Bolt	Purchased	No		140	Each	198.0000	1

Location	Loc Qty	Loc Code
ST356	198	
120770	82	
122141	116	

AN4-12A Bolt	Purchased	No		140	Each	467.0000	2

Location	Loc Qty	Loc Code
ST357	467	
120423	464	
121524	3	

AN5-10A Bolt	Purchased	No		140	Each	443.0000	4

Location	Loc Qty	Loc Code
ST337	443	
118191	80	
121243	100	
122151	263	

AN5-23A Bolt	Purchased	No		140	Each	23.0000	2

Location	Loc Qty	Loc Code
ST338	23	
113121	20	
113288	3	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped.
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Ovalized
☐ Over/Under tolerance
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Picklist Print

July-19-12 10:27:55 AM

Work Order ID: 87491
Parent Item: D130-701-041
Parent Item Name: Heli-Utility-Basket

Start Date: 7/10/12 **Required Date:** 9/07/12
Start Qty: 1.00 **Required Qty:** 1.00

[redacted] Washer	NAS1149D0463J	Purchased	No		140	Each	29.0000	5	5

Location	Loc Qty	Loc Code
ST351	29	
116289	8	
119097	21	

[redacted] Washer	NAS1149D0563J	Purchased	No		140	Each	12.0000	12	12

Location	Loc Qty	Loc Code
ST338	12	
2612	12	

[redacted] Nut		Purchased	No		140	Each	1,590.0000	3	3

Location	Loc Qty	Loc Code
ST300	1590	
104248	1	
119075	116	
121011	193	
121444	1280	

[redacted] Nut		Purchased	No		140	Each	1,038.0000	6	6

Location	Loc Qty	Loc Code
300	500	
121652	500	
ST300	538	
108827	4	
116105	5	
116548	43	
119109	474	
17651	4	
2937	8	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
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- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D130-701-041 (LH installation)	120 lb 54 kg	- 47.4 in - 1.20 m	- 5688 in-lb - 64.8 m-kg	133.9 in 3.40 m	16068 in-lb 183.6 m-kg
D130-701-041 (RH installation)	120 lb 54 kg	+ 47.4 in + 1.20 m	+ 5688 in-lb + 64.8 m-kg	133.9 in 3.40 m	16068 in-lb 183.6 m-kg
2 x D130-701-041 (LH and RH installation)	224 lb 102 kg	0.0 in 0.00 m	0 in- lb 0.0 m-kg	133.9 in 3.40 m	29994 m-kg 346.8 m-kg
D130-701-043 (LH installation)	130 lb 59 kg	- 47.4 in - 1.20 m	- 6162 in-lb - 70.8 m-kg	133.9 in 3.40 m	17407 in-lb 200.6 m-kg
D130-701-043 (RH installation)	130 lb 59 kg	+ 47.4 in + 1.20 m	+ 6162 in-lb + 70.8 m-kg	133.9 in 3.40 m	17407 in-lb 200.6 m-kg
2 x D130-701-043 (LH and RH installation)	235 lb 106.8 kg	0.0 in 0.00 m	0.0 in-lb 0.00 m-kg	133.9 in 3.40 m	31467 in-lb 363.1 m-kg
D130-701-013 (Fixed provisions)	25 lb 11.4 kg	0.0 in 0.00 m	0.0 in-lb 0.00 m-kg	133.9 in 3.40 m	3348 in-lb 38.8 m-kg

5. PARTS LIST

Qty -041	Qty -043	Qty -011	Qty -013	Part Number	Description
X				D130-701-041	HELI-UTILITY-BASKET
	X			D130-701-043	HELI-UTILITY BASKET
		X		D130-701-011	CONVERSION KIT
			X	D130-701-013	FIXED PROVISIONS KIT
2	2			*D2022-101	SPACER
1	1			*D2258-220	LABEL
1	1			*D2332-041	PROP ASSEMBLY
1	1			*D2512	BASKET LID ASSEMBLY
1	1			*D2530	HANDLE ASSEMBLY
2	2			*D2535	SPRING
2	2			*D2537	BUSHING
2	2			*D2931	BUMPER
1	1			*D3172-041	BASKET BASE ASSEMBLY
2				D3173-041	BEAM ASSEMBLY
1				D3177-041	BRACKET ASSEMBLY
1				D3177-043	BRACKET ASSEMBLY
1	1			D3180-041	STRUT ASSEMBLY
1	1			D3181-1	BUSHING
	1	1	1	D4037-1	AFT CHANNEL
	1	1	1	D4037-3	FWD CHANNEL
	1	1	1	D4038-041	ANGLE ASSEMBLY, FWD, LH
	1	1	1	D4038-042	ANGLE ASSEMBLY, FWD, RH
	1	1	1	D4038-043	ANGLE ASSEMBLY, AFT, LH
	1	1	1	D4038-044	ANGLE ASSEMBLY, AFT, RH
	1	1		D4039-041	FWD BRACKET ASSEMBLY
	1	1		D4039-043	AFT BRACKET ASSEMBLY
	4	4	4	D4040-1	RADIUS BLOCK
	1	1		*D4090-1	PLACARD (ON BASKET LID)
	1	1		*D4090-3	PLACARD (ON BASKET LID)

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REFERENCE ONLY

Qty -041	Qty -043	Qty -011	Qty -013	Part Number	Description
	1	1	1	D4090-5	PLACARD
2	2			*AN3-16A	BOLT
2	2			*AN4-12A	BOLT
1	1			*AN4-22A	BOLT
1	1			*AN4-24A	BOLT
3 (2)	3 (2)			+AN4-7A	BOLT
4	16	16	16	*AN5-10A	BOLT
4	4			*AN5-17A	BOLT
2				*AN5-23A	BOLT
4	4			*AN970-4	WASHER
	8	8	8	MS20002C5	WASHER
	12	12		MS20002C6	WASHER
2	2			*MS20600AD4W3	RIVET
2	2			*MS21042L3	NUT (OR MS21042-3)
7 (4)	7 (4)			+MS21042L4	NUT (OR MS21042-4)
10 (4)	28 (4)	24	24	+MS21042L5	NUT (OR MS21042-5)
	12	12		MS21042L6	NUT (OR MS21042-6)
	4	4	4	MS21250-05032	BOLT
	4	4	4	MS21250-05038	BOLT
	12	12		MS21250-06018	BOLT
2	2			*NAS1149DN832J	WASHER (AN960JD8)
2	2			*NAS1149D0416J	WASHER (AN960JD416L)
7 (2)	7 (2)			+NAS1149D0463J	WASHER (AN960JD416)
16 (4)	44 (4)	40	40	+NAS1149D0563J	WASHER (AN960JD516)
	12	12		NAS1149D0663J	WASHER (AN960JD616)

* Pre-assembled prior to shipping
\+ Quantity in () preassembled prior to shipping

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